

# Work Order ID 47001

June 26, 2009 4:12:56 PM



Page 1

Item ID: D350-600-241  
Revision ID: C  
Item Name: Spacepod, LH, AS350

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D350-600-241  
CHG 001

*df 09/05/11 S 09/07/22*

110

0.00



Small Fab

Small Fab

Memo

1-Drill holes in D3188-1 using drill jig Dt8970  
2-Open holes in D3188-1 body floor to 0.297" as per dwg D3188  
3-Deburr  
4-Install inserts in D3188-1 as per dwg D3188

*RT 09-07-20*

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

*=> S 9/7/21*

*(10)*

# Work Order ID 47001

June 26, 2009 4:12:56 PM



Page 2

Item ID: D350-600-241

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, LH, AS350

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1

Small Fab

*Mon/07/28* *Already cut on water jet previously see page 1 picklist sheet.*

140

0.00



Small Fab

Memo

0.00

\*\*\* this step separates hardware, previous steps is for baody & floor\*\*\*

Small Fab

*h*

# Work Order ID 47001

June 26, 2009 4:12:56 PM



Page 3

Item ID: D350-600-241

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, LH, AS350

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00



Small Fab

Memo

0.00

ET 09-07-20

Small Fab

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600  
\*\*\*Hardware on previous steps is for door ass'y\*\*\*

1-drill and plug section I-I and J-J of dwg D3188 p. 11 using Hysol 934NA with  
milled glass fibres 10% to weight  
A/R Hysol batch: 110970  
xpiry date: Dec 0709  
A/R Milled fibers batch: 100859

2-Attach Neoprene Foam using Contact cement  
A/R Contact cement Batch: 112251/1 floor epoxide

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 or 1/2

41

# Work Order ID 47001

June 26, 2009 4:12:56 PM



Page 4

Item ID: D350-600-241

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, LH, AS350

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Wing Walk as per dwg QS1005 4.4 Batch 2110013 0.00



HandFinish

Memo

0.00

Hand Finishing

UMD 09/07/21

(X1)

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BL 09-07-21

190

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 80% 2/20

(+16H)

f

# Work Order ID 47001

June 26, 2009 4:12:56 PM



Page 5

Item ID: D350-600-241

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, LH, AS350

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-241

Location: \_\_\_\_\_  
PPP rev: \_\_\_\_\_

Don't 07/27

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/7/22 (1)

09/07/27

MF 09-07-24

# Picklist Print

June 26, 2009 4:12:55 PM

Page 1

Work Order ID: 47001

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod. LH, AS350

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3188-1MRevE		Manufactured	No			110	Each	0.0000	1.0000			
SPACEPOD BODY LH												
D3186-3RevD		Manufactured	No			110	Each	0.0000	1.0000			
Spacepod Door, LH												
D3187-1RevC		Manufactured	No			110	Each	12.0000	1.0000			
Spacepod Floor												
ALS4-1032-130		Purchased	No			110	Each	7,849.000	28.0000			
Insert												
A3235-020-935		Purchased	No			110	Each	815.0000	8.0000			
Washer - Countersunk												
D2986-1RevB		Manufactured	No			130	Each	6.0000	1.0500			
Rubber Spacer												
D3015-3RevB		Manufactured	No			140	Each	435.0000	1.0000			
Locknut												
D3554-7RevA		Manufactured	No			140	Each	81.0000	1.0000			
Ball Stud												
D3567-1RevA		Manufactured	No			140	Each	29.0000	1.0000			
Decal												

45698A 10 9/7/24

45690 10 9/7/24

31835 25

110511 SP  
106150 SP

48237 SP

48238 SP

37674 SP

09/07/28

9/7/28 (10)

# Picklist Print

June 26, 2009 4:12:55 PM

Work Order ID: 47001

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516 <i>instaled</i>		Purchased	No			140	Each	1,603.000	1.0000			
Washer												
D2237RevD1 <i>instaled</i>		Manufactured	No			140	Each	30.0000	2.0000			
Striker Plate												
MS20426AD4-5		Purchased	No			140	Each	7,958.000	4.0000			
Rivet												
D3538-1RevA		Manufactured	No			140	Each	40.0000	2.0000			
Hinge Bracket												
D2179RevB		Manufactured	No			140	Each	95.0000	2.0000			
Doubler												
AN526C832R24		Purchased	No			140	Each	144.0000	4.0000			
screw												
AN960JD8		Purchased	No			140	Each	1,143.000	4.0000			
Washer												
MS21042L08		Purchased	No			140	Each	306.0000	4.0000			
Nut												
MS27039-08-11		Purchased	No			150	Each	139.0000	2.0000			
Screw												

111279 SP

46142 SP

4067 SP

44650 SP

35432 SP

104603 SP

111578 SP

112243 SP

108335 SP

9/1/00 SP

June 26, 2009 4:12:55 PM

Shop Packet Print

# Picklist Print

June 26, 2009 4:12:55 PM

Page 3

Work Order ID: 47001

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350







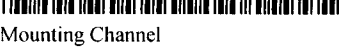
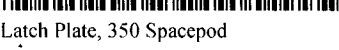

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 		Purchased	No			150	Each	1,143.000	16.0000			
Washer NAS1515H3 		Purchased	No			150	Each	530.0000	2.0000			
Washer MS21042L08 		Purchased	No			150	Each	306.0000	14.0000			
Nut D2464RevB 		Manufactured	No			150	f	896.4300	11.3400			
3/4 Seal D3567-1RevA 		Manufactured	No			150	Each	29.0000	1.0000			
Decal D2586RevD 		Manufactured	No			150	Each	80.0000	2.0000			
Door Latch D2585RevB 		Manufactured	No			150	Each	22.0000	2.0000			
Mounting Channel D2621RevB 		Manufactured	No			150	Each	91.0000	2.0000			
Latch Plate, 350 Spacepod MS27039-1-15 		Purchased	No			150	Each	116.0000	2.0000			
Screw												

111578 SY

110397 SD

112043 SD

39669 AS 09-07-20

48254 AS 09-07-20

47183 SY

45888 SD

46842 SD

111916 SD

9/1/20

June 26, 2009 4:12:55 PM

Shop Packet Print

Page 3



# Picklist Print

June 26, 2009 4:12:55 PM

Page 4

Work Order ID: 47001

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 		Purchased	No			150	Each	1,246.000	2.0000			
Washer MS21042L3 		Purchased	No			150	Each	1,873.000	2.0000			
Nut D2857-1RevB 		Manufactured	No			150	Each	30.0000	1.0000			
Hinge Bracket D2857-2RevB 		Manufactured	No			150	Each	38.0000	1.0000			
Hinge Bracket D2228RevB 		Manufactured	No			150	Each	120.0000	4.0000			
Bracket Plate AN526C832R10 		Purchased	No			150	Each	195.0000	10.0000			
Screw D3557-1RevA 		Manufactured	No			150	Each	18.0000	1.0000			
Bracket AN526C832R10 	12 090720	Purchased	No			150	Each	1,051.000	2.0000			
Screw K10021RevN/A 		Manufactured	No			190	Each	5.0000	1.0000			
Spacepod Hardware Kit (-241)												

111668 SP

111274 SP

45788 SP

43363 SP

30679 SP

104603 SP

132617 SP

107285  
102 104916 SP

41341 109121 (1)

91120 @

Shop Packet Print

Page 4

June 26, 2009 4:12:55 PM

# Picklist Print

June 26, 2009 4:12:55 PM

Page 5

Work Order ID: 47001

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350






Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S D350-600-449RevC 		Manufactured	No			190	Each	7.0000	1.0000	 41358		
Switch Relocation												
S D2985RevA1 		Manufactured	No			190	Each	19.0000	1.0000	 48236		
Label												
S D3547-1RevA 		Manufactured	No			190	Each	20.0000	1.0000	 35406		
Bracket												
S D3550-1RevB 		Manufactured	No			190	Each	31.0000	1.0000	 45570		
Strut												
S D3552-7RevD 		Manufactured	No			190	Each	16.0000	1.0000	 32644		
Door Prop												
S D3554-7RevA 		Manufactured	No			190	Each	81.0000	1.0000	 37674		
Ball Stud												
S AN960JD516 21-115 		Purchased	No			190	Each	1,603.000	2.0000	 1111279		
Washer												
S D3015-3RevB 		Manufactured	No			190	Each	435.0000	1.0000	 48238		
Locknut												

9/7/20 @SQ

June 26, 2009 4:12:55 PM

Shop Packet Print

Page 5

Date: Tuesday, 07/04/2009 10:26:50 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SPACEPOD ASSEMBLY LH/ DSI 9335
<b>Job Number</b> :	47001		
<b>Estimate Number</b> :	12775		
<b>P.O. Number</b> :		<b>Part Number</b> :	D350600241
<b>This Issue</b> :	07/04/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	IIN REV.C PG11,18-21
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	45711	<b>Drawing Revision</b> :	C
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JUD 09.04.07	<b>Due Date</b> :	10/05/2009
<b>Comment</b> :	Est Rev:A 07.03.07 new issue ec	<b>Qty:</b>	1
	est rev B 07.04.16 reformat,D3188 revE ec	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-241 CHG001

2.0

✓ 47001A

SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

1 x D3188-1M Batch

3.0

✓ 47001B

SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

1 x D3186-3 Batch

4.0

✓ D31871

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1

Floor

5.0

✓ ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

insert

batch: 110511

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

A3235020935

Washer - Countersunk



106750



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes in D3188-1 using drill jig DT8970

2-Open holes in D3188-1 body floor to Ø0.297" as per dwg D3188

3-Deburr

4-Install inserts in D3188-1 as per Dwg D3188.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

D2986

Black Neoprene Foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

neoprene foam

batch: \_\_\_\_\_

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

11.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lock Nut

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #: ☒ Machine Or Operation:

Description :

12.0

☒ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: \_\_\_\_\_

13.0

☒ D35671

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: \_\_\_\_\_

14.0

☒ AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: \_\_\_\_\_

15.0

☒ D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: \_\_\_\_\_

16.0

☒ MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: \_\_\_\_\_

17.0

☒ D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: \_\_\_\_\_

18.0

☒ D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #: Machine Or Operation: Description :

19.0 ✓ AN526C832R24 screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: \_\_\_\_\_

20.0 ✓ AN960JD8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: \_\_\_\_\_

21.0 ✓ MS21042L08 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: \_\_\_\_\_

22.0 ✓ SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

\*\*\*this step seperates hardware, previous steps is for body & floor\*\*\*\*

23.0 ✓ MS270390811 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

24.0 ✓ AN960JD8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: \_\_\_\_\_

25.0 ✓ NAS1515H3 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

✓ MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: \_\_\_\_\_

27.0

✓ D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: \_\_\_\_\_

28.0

✓ D35671

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: \_\_\_\_\_

29.0

✓ D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: \_\_\_\_\_

30.0

✓ D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: \_\_\_\_\_

31.0

✓ D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: \_\_\_\_\_

32.0

✓ MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

33.0	✓ AN960JD10	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

34.0	✓ MS21042L3	Nut
------	-------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: \_\_\_\_\_

35.0	✓ D28571	Hinge Bracket
------	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: \_\_\_\_\_

36.0	✓ D28572	Hinge Bracket
------	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: \_\_\_\_\_

37.0	✓ D2228	Bracket Plate
------	---------	---------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: \_\_\_\_\_

38.0	✓ AN526C832R10	Screw
------	----------------	-------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: \_\_\_\_\_

39.0	✓ AN960JD8	Washer
------	------------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0



MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: \_\_\_\_\_

41.0



D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: \_\_\_\_\_

42.0



AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

43.0



AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

44.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: \_\_\_\_\_ expire date: \_\_\_\_\_

A/R Milled fibres batch: \_\_\_\_\_

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #: Machine Or Operation: Description :

45.0 ✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

46.0 ✓

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: \_\_\_\_\_

47.0 ✓

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

48.0 ✓

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

49.0 ✓

D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

50.0 ✓

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

51.0 ✓

D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: \_\_\_\_\_

52.0 ✓

D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:26:50 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 47001

Part Number: D350600241

Job Number:



Seq. #: Machine Or Operation: Description :

53.0

✓ D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
CARBON STEEL GAS SPRING

batch: \_\_\_\_\_

54.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BALL STUD

batch: \_\_\_\_\_

55.0

✓ AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

56.0

✓ D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: \_\_\_\_\_

57.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

58.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

59.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



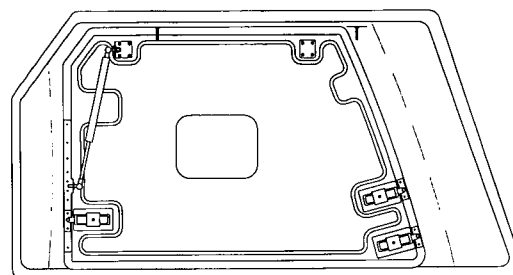
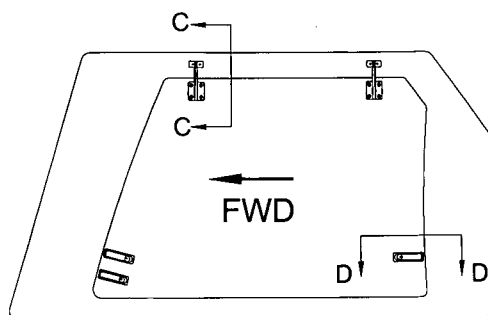
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

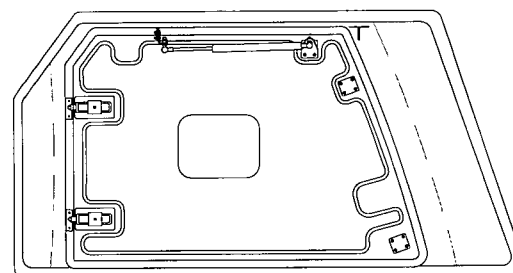
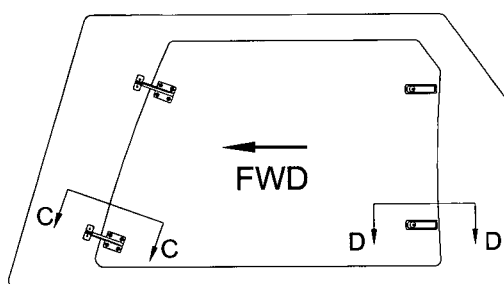
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

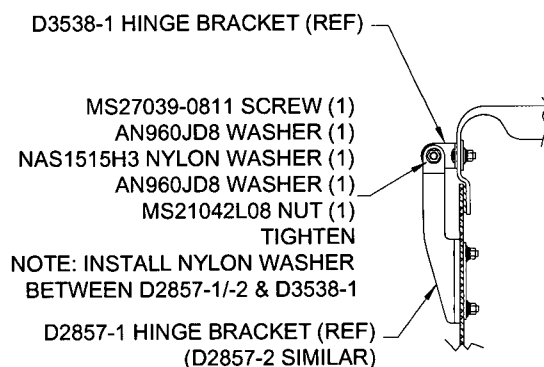
**NOTE:** Date & initial all entries



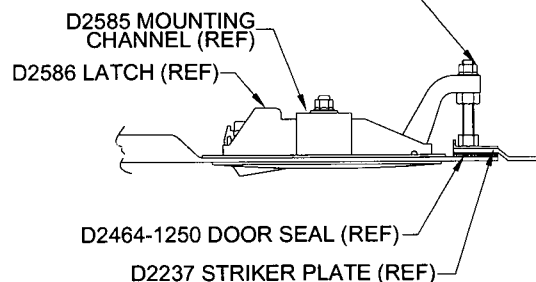
**FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



ADJUST SCREW TO ENSURE  
COMPRESSION OF DOOR SEAL  
AND LOCK IN POSITION WITH NUT



**SECTION 'C-C' HINGE**  
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)

**SECTION 'D-D' LATCH**

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

NO FURTHER ACTION

WITH NOTICE

ORDER

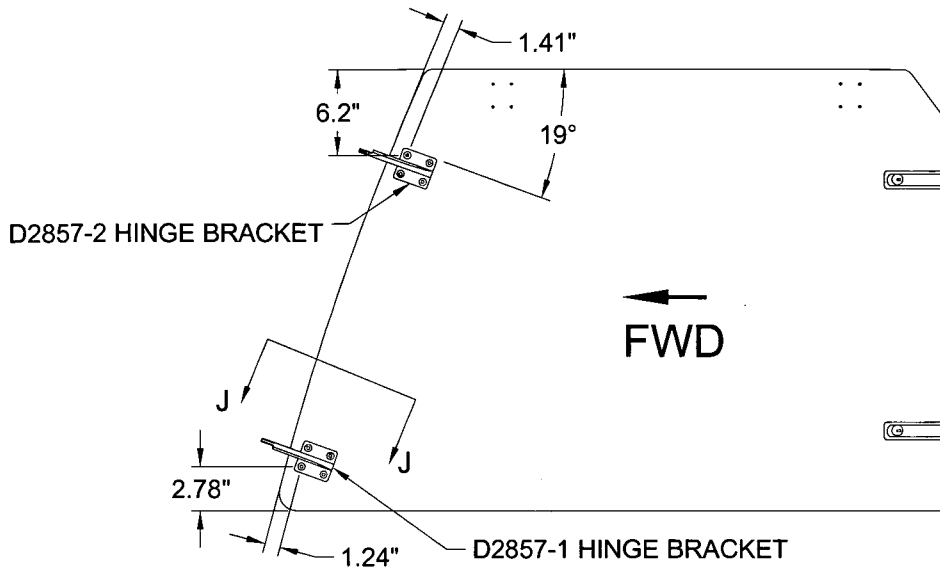
47001

• COPYRIGHT © 2006 BY DART AEROSPACE LTD •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

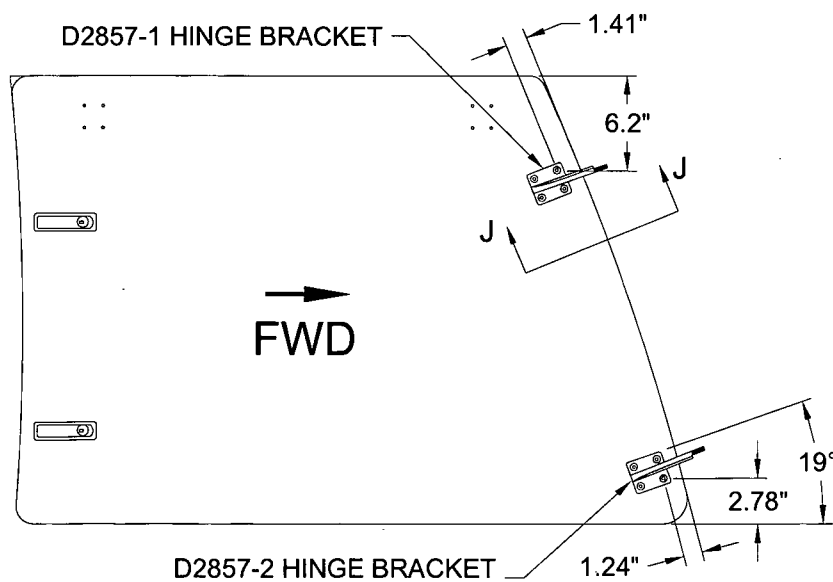
Revision: **C**

Date: 07.02.20

- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the  $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

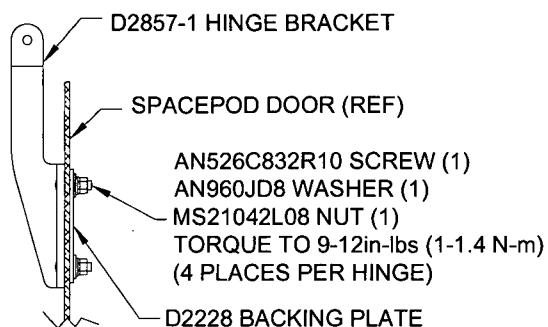


**FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR**



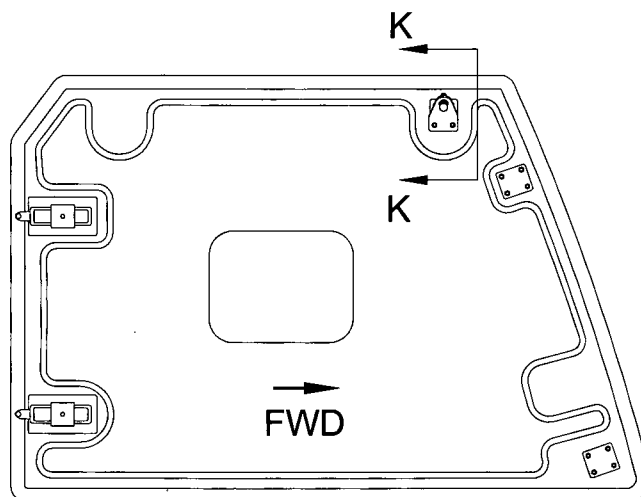
**FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
47001

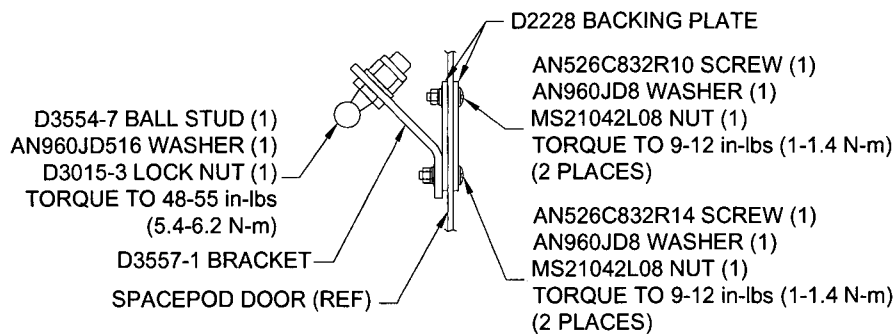


**SECTION 'J-J' HINGE BRACKET INSTALLATION**  
 (D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.



**FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR**  
 (INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



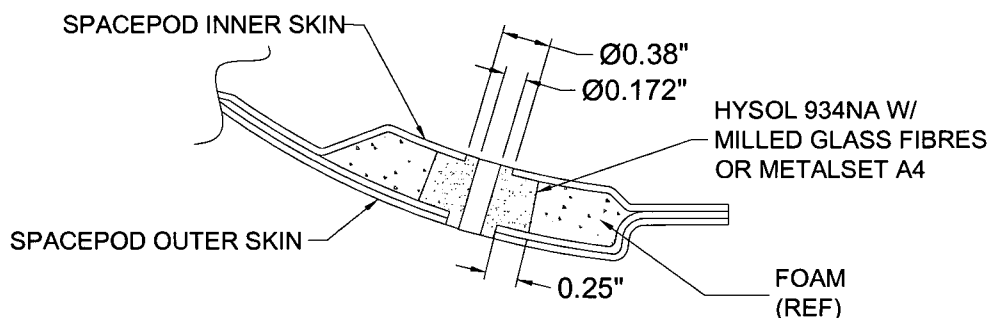
**SECTION 'K-K'**

• COPYRIGHT © 2006 BY DART AEROSPACE LTD •  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

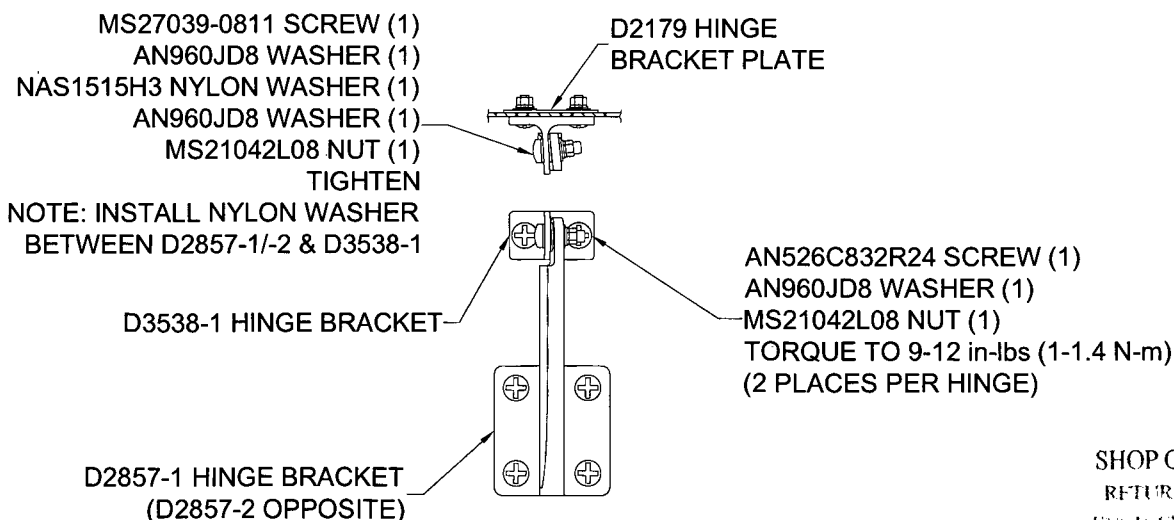
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBMIT TO MANAGEMENT  
 WORK IN PROGRESS  
 NO. 47001

Revision: C  
 Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
  - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
  - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
  - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
  - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).



**FIGURE 17(a). COMPOSITE MODIFICATION**



**FIGURE 17(b). HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 OPPOSITE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WHICH MAY BE  
ISSUED WITHOUT  
NOTICE  
NO. 47001